

Work Order ID 84511

May-15-12 10:38:18 AM

SHIP JUNE 8

84511

Page 1

Item ID: D412-742-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Float Skidtube Installation

Start Date: 15/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MJS

Date: 12/05/15

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D412-742

E

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-742-011 CHG007

MJS 12/05/12

W 12-06-12

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

12/5/23

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

W 12-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84511

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Page 2

Item ID: D412-742-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Float Skidtube Installation

Start Date: 15/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-742-011								
	Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 12/06/12
CMF
12-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 84511

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Parent Item: D412-742-011

D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 15/05/2012

Required Date: 06/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev: A05.10.13New IssueKJ/JLM
 IPP Rev:B 06-06-08 As per DSI9336 JLM
 IPP Rev:C 07-05-28 As per Rev C JLM
 IPP rev D 07.11.01 ecn 1053P EC
 IPP rev E 07.11.27 ecn 1072 EC verified by:DD
 IPP Rev:F 08-09-08 ecn 08-510 DD verified by:EC
 IPP Rev:G 09-01-23 as per DSI9441 DD verified by:EC IPP Rev:H
 11.11.01 as per DSI9517 REV.B DD verified by:EC IPP rev:I 12.01.12
 PER IIN REV.E DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3407-041 *D3407-041* Tow Ring		Manufactured	No			110	Each	39.0000	1	1			
<div>Location</div> <div>ST463</div> <div>82067</div> <div>82068</div> <div>82108</div> <div>Loc Qty</div> <div>39</div> <div>9</div> <div>27</div> <div>3</div> <div>Loc Code</div>													
D3417-3 *D3417-3* Washer		Manufactured	No			110	Each	39.0000	2	2			
<div>Location</div> <div>FG</div> <div>33519</div> <div>ST042</div> <div>80225</div> <div>Loc Qty</div> <div>9</div> <div>9</div> <div>30</div> <div>30</div> <div>Loc Code</div>													
D412-742-041 *D412-742-041* Replacement Float Skidtube		Manufactured	No			110	Each	0.0000	1	1			

384522 06/06/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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84511

Parent Item: D412-742-011

D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 15/05/2012

Required Date: 06/06/2012

Start Qty: 1.00

Required Qty: 1.00

D412-742-015

Manufactured No

110 Each

1.0000

**** 1**

D412-742-015

Electric Step

Location

Loc Qty

Loc Code

FG121

1

69061

1

Manufactured No

110 Each

6.0000

**** 1**

D2571

D2571

Saddle, Fwd Out 205

Location

Loc Qty

Loc Code

ST

1

11644

1

ST425

-13

ST432

5

82049

5

ST433

13

Manufactured No

110 Each

2.0000

**** 1**

D2572

D2572

Saddle, Fwd In 205

Location

Loc Qty

Loc Code

ST432

2

71107

2

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 84511

Parent Item: D412-742-011

Parent Item Name: Float Skidtube Installation

84511

D412-742-011

Start Date: 15/05/2012

Required Date: 06/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2573
Saddle, Aft Out 205

Manufactured No

110 Each

22.0000

**** 1 1**

B83453

Location

Loc Qty

Loc Code

ST423

-12

79424

0

ST433

22

82048

4

83454

6

83669

12

ST434

12

Manufactured No

110 Each

22.0000

**** 1 1**

B83455

Location

Loc Qty

Loc Code

ST433

22

82368

4

83456

6

83671

12

Manufactured No

110 Each

73.0000

**** 2 2**

25/20

D2876
Saddle Spacer

Location

Loc Qty

Loc Code

ST020

73

79693

33

83323

40

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 84511

84511

Parent Item: D412-742-011

D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 15/05/2012

Required Date: 06/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2877
Saddle Spacer

Manufactured No

110 Each

63.0000

**

Location

Loc Qty

Loc Code

ST020

63

82026

23

83324

40

Manufactured No

110 Each

87.0000

**

Location

Loc Qty

Loc Code

ST041

15

70696

15

ST042

72

80208

7

80219

4

81529

61

Manufactured No

110 Each

70.0000

**

Location

Loc Qty

Loc Code

ST042

70

81531

70

Manufactured No

110 Each

220.0000

**

Location

Loc Qty

Loc Code

ST017

220

79520

20

81877

200

D3403-5
Bushings

D2747
Set Screw

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 84511

84511

Parent Item: D412-742-011

D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 15/05/2012

Required Date: 06/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3533-1

Manufactured No

110

Each

130.0000

D3533-1

Set Screw

**

Location

Loc Qty

Loc Code

ST053

130

80326

30

83892

100

Purchased

No

110

Each

667.0000

AN4C6A

AN4C6A

Bolt

**

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

663

116704

2

121656

161

21658

500

Purchased

No

110

Each

72.0000

AN4C52A

AN4C52A

BOLT

**

Location

Loc Qty

Loc Code

ST361

72

117688

6

120364

66

Purchased

No

110

Each

38.0000

AN4C53A

AN4C53A

Bolt

**

Location

Loc Qty

Loc Code

ST361

38

121183

38

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Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 84511

84511

Parent Item: D412-742-011

D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 15/05/2012

Required Date: 06/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN6C12A
BOLT

Purchased No

110 Each

62.0000

8
**

8

Location

Loc Qty

Loc Code

ST341

62

121302

22

121541

40

Manufactured No

110 Each

5.0000

32
**

32

D3672-3
Phenolic Washer

Location

Loc Qty

Loc Code

ST060

5

83238

5

Purchased No

110 Each

0.0000

32
**

32

***AN960C416I ***
WASHER

Manufactured No

110 Each

380.0000

8
**

8

D3672-9
Phenolic Washer

Location

Loc Qty

Loc Code

ST060

380

81763

380

Purchased No

110 Each

55.0000

8
**

8

NAS1149C0632R
WASHER

Location

Loc Qty

Loc Code

ST297

55

119736

2

121060

53

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 84511

84511

Parent Item: D412-742-011

D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 15/05/2012

Required Date: 06/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3672-11

Manufactured No

110 Each

275.0000

8

**

D3672-11

Phenolic Washer

Location

Loc Qty

Loc Code

ST060

275

77483

275

Purchased No

110 Each

1,546.000

29

**

MS21043-4

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1506

119546

185

121162

821

121652

500

Purchased No

110 Each

159.0000

4

**

AN4G7A

AN4G7A

Bolt

Location

Loc Qty

Loc Code

ST356

159

109147

159

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 84511

Parent Item: D412-742-011

Parent Item Name: Float Skidtube Installation

84511

D412-742-011

Start Date: 15/05/2012

Required Date: 06/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3591-1*

Manufactured No

110

Each

104.0000

2

2

D3591-1

Bushing

**

Location

Loc Qty

Loc Code

FP

5

80377

4

82027

1

ST055

99

57350

1

83237

98

Manufactured No

110

Each

23.0000

8

D3403-3*

D3403-3

Bushing

**

Location

Loc Qty

Loc Code

ST042

23

81530

23

Manufactured No

110

Each

18.0000

1

D3405-041*

D3405-041

Lug Assembly

**

Location

Loc Qty

Loc Code

ST478

18

62227

2

77000

2

82031

1

82032

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 84511

84511

Parent Item: D412-742-011

D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 15/05/2012

Required Date: 06/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3405-043

Manufactured No

110

Each

14.0000

D3405-043

Lug Assembly

**

Location

Loc Qty

Loc Code

ST

3

58328

0

82037

3

ST478

11

82038

11

Purchased

No

110

Each

64.0000

AN4C47A

AN4C47A

Bolt

**

Location

Loc Qty

Loc Code

ST361

64

118451

6

119798

2

121009

22

121585

34

Manufactured

No

110

Each

172.0000

D3456-1

D3456-1

Washer

**

Location

Loc Qty

Loc Code

FG

7

25701

7

ST044

165

80252

1

81876

64

83584

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D412-742-011

D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 15/05/2012

Required Date: 06/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C37A

Purchased

No

110

Each

175.0000

3

3

AN3C37A

BOLT

**

Location

Loc Qty

Loc Code

ST354

175

116874

11

117010

2

120422

4

*121068

100

121584

8

121585

50

Purchased

No

110

Each

31.0000

2

2

AN3C40A

AN3C40A

BOLT

**

Location

Loc Qty

Loc Code

ST354

31

114442

31

Purchased

No

110

Each

172.0000

3

3

AN3C41A

AN3C41A

BOLT

**

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

168

120753

30

121013

50

121313

80

121689

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D412-742-011

D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 15/05/2012

Required Date: 06/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3G42A

Purchased

No

110

Each

42.0000

3

3

**

AN3C42A

BOLT

Location

Loc Qty

Loc Code

ST354

42

106176

1

120464

16

121103

25

Purchased

No

110

Each

105.0000

3

3

**

AN3C43A

AN3C43A

BOLT

Location

Loc Qty

Loc Code

ST354

105

114455

2

119673

1

120364

2

120465

100

Purchased

No

110

Each

53.0000

9

9

**

AN3C44A

AN3C44A

BOLT

Location

Loc Qty

Loc Code

ST354

53

110848

53

Purchased

No

110

Each

36.0000

10

10

**

AN3C47A

AN3C47A

BOLT

Location

Loc Qty

Loc Code

ST355

36

116874

26

121103

10

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W/O:		WORK ORDER CHANGES					
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Parent Item: D412-742-011

D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 15/05/2012

Required Date: 06/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN960C10L

NAS1149C0332

Purchased

No

110

Each

0.0000

66

66

***AN960C10L ***

washer

MS21043-3

Purchased

No

100

Each

1,767.000

33

33

MS21043-3

Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

30

120693

30

ST301

1665

118077

2

118614

51

118686

30

119758

20

121255

562

121708

1000

33

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

(CONTINUED FROM PAGE 17)

Item	Qty -011	Qty -041	Qty -015	Part Number	Description
46A	8			D3403-1	BUSHING
46B	8			D3403-5	BUSHING
47A	4			D2747	SET SCREW
47B	2			D3533-1	SET SCREW
48	16			AN4C6A	BOLT
49A	4			AN4C52A	BOLT
49B	4			AN4C53A	BOLT
50	8			AN6C12A	BOLT
51A	32			D3672-3	WASHER (REPLACES NAS1515H4L)
51B	32			AN960C416L	WASHER
52A	8			D3672-9	WASHER (REPLACES NAS1515H6L)
52B	8			AN960C616L	WASHER
53	8			D3672-11	WASHER (REPLACES NAS1515H7L)
54	24			MS21043-4	NUT
55	4			AN4C7A	BOLT
56	2			D3591-1	BUSHING
60	8			D3403-3	BUSHING
61	1			D3405-041	GHW LUG
62	1			D3405-043	GHW LUG
63	4			AN4C47A	BOLT
64	4			MS21043-4	NUT
70	1			D3407-041	TOW RING
71	2			D3417-3	WASHER
72	1			MS21043-4	NUT
73	1			D3456-1	WASHER
80			1	D2913	DOUBLER
81		***4		***ALS4-428-165	***INSERT (REPLACES NAS1329S4KB140)
82		***4		***EL-1032-130	***INSERT (REPLACES NAS1330S3KB116)
83			2	MS21043-4	NUT
84			2	MS24693-C272	SCREW
85			1	MS35489-35	GROMMET
86			1	MS35489-93	GROMMET
87		***4		***MS27039C1-09	***SCREW
88		***4		***MS27039C4-08	***SCREW
89A		***4	2	***D3672-1	***WASHER (REPLACES NAS1515H3L)
89B		***4	2	***AN960C10L	***WASHER
90A		***4		***D3672-3	***WASHER (REPLACES NAS1515H4L)
90B		***4		***AN960C416L	***WASHER
91	3			AN3C37A	BOLT
92	2			AN3C40A	BOLT
93	3			AN3C41A	BOLT
94	3			AN3C42A	BOLT
95	3			AN3C43A	BOLT
96	9			AN3C44A	BOLT
98	10			AN3C47A	BOLT
99	66			AN960C10L	WASHER
100	33			MS21043-3	NUT

*DENOTES PART IS INCLUDED WITH D3391-041 ASSEMBLY ABOVE

**DENOTES THAT PART IS INCLUDED ABOVE ASSEMBLY

***DENOTES THAT PART IS INCLUDED WITH D3391-013

5.0 PARTS LIST

5.1 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List

Item	Qty -011	Qty -041	Qty -015	Part Number	Description
	X			D412-742-011	FLOAT SKIDTUBE INSTALLATION
	1	X		D412-742-041	FLOAT SKIDTUBE
	1		X	D412-742-015	ELECTRIC STEP KIT
		1		D3391-041	412 FLOAT SKIDTUBE
1		*24		*AN3C4A	*BOLT
3		*10		*AN3C6A	*BOLT
4		*4		*AN3C7A	*BOLT
5		*38		*AN960C10L	*WASHER
6		*4		*MS27039C4-12	*SCREW
7A		*4		*D3672-3	*WASHER (REPLACES NAS1515H4L)
7B		*4		*AN960C416L	*WASHER
21		*1		*D4095-041	*WEARSHOE (REPLACES D3564-1)
22		*1		*D4095-043	*WEARSHOE (REPLACES D3564-3)
23		*1		*D4095-045	*WEARSHOE (REPLACES D3564-5)
10		*1		*D3391-011	*412 FORWARD TUBE
11		**1		**D3401-041	**TOW CAP
12A		**10		**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB166)
13		**10		**AN3C4A	**BOLT
14A		**4		**D3672-1	**WASHER (REPLACES NAS1515H3L)
14B		**10		**AN960C10L	**WASHER
24		**1		**D4095-051	**WEARSHOE (REPLACES D3564-13)
20		*1		*D3391-013	*412 MID TUBE
28		**24		**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB116)
30		*1		*D3391-015	*412 AFT TUBE
25		**1		**D4095-049	**WEARPAD (REPLACES D3537-1)
26		**1		**D4095-047	**WEARPAD (REPLACES D3537-7)
31		**1		**D2646	**AFT CAP
32		**14		**AELS-1032-130	**INSERT
36		**8		**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB366)
37A		**6		**AN3C4A	**BOLT
37B		**4		**AN3C5A	**BOLT
38A		**2		**D3672-1	**WASHER (REPLACES NAS1515H3L)
38B		**10		**AN960C10L	**WASHER
39		**4		**ALS4-428-165	**INSERT (REPLACES NAS1330S4KB151)
40	1			D2571	SADDLE, FWD OUTSIDE
41	1			D2572	SADDLE, FWD INSIDE
42	1			D2573	SADDLE, AFT OUTSIDE
43	1			D2574	SADDLE, AFT INSIDE
44	2			D2876	SADDLE SPACER
45	2			D2377	SADDLE SPACER

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